

Work Order ID 53124



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October 22, 2009 4:23:39 PM

Item ID: D2892-1

Accept



Setup Start



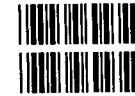
Revision ID: A

Stop



Item Name: Support

Start Date: 23/10/2009 Start Qty: 14.00



Cust Item ID:

Required Date: 30/11/2009 Req'd Qty: 14.00



Customer:

Reference:

Approvals: Process Plan: PLDate: 27/10/22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2892	Rev A

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

0.00

Memo

HAAS CNC vertical machine #1

Machine as per Folio FA082 Tumble & Deburr

SL/mw
09/11/03

13 1

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

SL/mw
09/11/03

B 1

QC

Memo

Quality Control

120

0.00



QC8- Inspect parts - second check

0.00

Memo

Quality Control

ark 09/11/03

13 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2892-1 PAR #: Fault Category: Machined parts, NCR: Yes No DQA: ✓ ^{2nd NCR} Date: 09/11/24
 Resolution: SCRAP Disposition: Scrap QA: N/C Closed: ✓ Date: 09/11/24

NCR: 53124		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/11/02	100	HEIGHT OF TABS IS 0.030 (DWG = 0.050)	<u>CP</u> 09/11/02 PC 09/11/02	Acceptable	<u>SL</u> 09/11/02	<u>CP</u> 09/11/04	<u>CP</u> 09/11/02 PC 09/11/02	<u>SL</u> 09/11/04
09/11/02	100	1 part is scraped, engraving tool didn't raise high enough and touched part while running on R1.487 was changed to R1.750	<u>CP</u> 09/11/02 PC 09/11/02	Scrap & replace Fix Prog R1.487 was changed to R1.750	<u>SL</u> 09/11/02	<u>CP</u> 09/11/04 PC 09/11/02	<u>CP</u> 09/11/04 PC 09/11/02	<u>SL</u> 09/11/04
		4th axis, leaving a deep groove in part R.C. program error						

NOTE: Date & initial all entries

Work Order ID 53124



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Item ID: D2892-1

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Setup Start



Revision ID: A

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Item Name: Support

Start Date: 23/10/2009 Start Qty: 14.00



Cust Item ID:

Required Date: 30/11/2009 Req'd Qty: 14.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat

Powder Coating

11/12/48

=> 08/11/04

(13) 8

140



QC3- Inspect Part Finish

0.00

11/09/11/05

x13

QC

Quality Control

Memo

0.00

150



Identify as per dwg & Stock Location: X-tiles

0.00

Packaging

Packaging

Memo

0.00

11 09 11 09 (13)

Work Order ID 53124

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Item ID: D2892-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Support

Start Date: 23/10/2009 Start Qty: 14.00



Cust Item ID:

Required Date: 30/11/2009 Req'd Qty: 14.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:	Stop	



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							



QC

Quality Control

Memo

0.00

09/11/09 JJ

11/09-13

Picklist Print

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Work Order ID: 53124



Parent Item: D2892-1 RevA



Parent Item Name: Support

Start Date: 23/10/2009

Required Date: 30/11/2009

Comments:

Start Qty: 14.00

Required Qty: 14.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSK077RevA		Manufactured	No			110	Each	17.0000	7.0000			

D2892-1 TURNING DETAIL

Location

Main Warehouse

Loc Qty

Loc Cod

MAT

42245

43386

43869

1

7

5

SL 0411102

DART AEROSPACE LTD		Work Order: <u>53124</u>
Description: Ø2.500 Support		Part Number: <u>D2892-1</u>
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article **Prototype**

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.130	.130	.131	.130	.131
AB	0.290	0.310		.300	.210	.310	.310	.310
AC	0.040	0.060		.049	.030	.030	.049	.049
AD	0.115	0.135		.126	.125	.125	.125	.125
AE	0.240	0.260		.251	.250	.251	.250	.249
AF	0.188	0.193		.188	.188	.188	.188	.188
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.137	1.139	1.135	1.134	1.137
AI	0.454	0.474		.466	.454	.454	.467	.467
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.257	.257	.257	.257	.257
AM	1.663	1.683		1.675	1.675	1.674	1.675	1.675
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: JL **Date:** 09/11/01

Audited by: CML **Date:** 09/11/03

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	<u>JLM</u>

DART AEROSPACE LTD		Work Order: 53124
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article **Prototype**

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
HAAS Section								
AA	0.115	0.135		.130	.130	.131	.131	.131
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.049	.050	.050	.052	.049
AD	0.115	0.135		.125	.125	.125	.125	.125
AE	0.240	0.260		.249	.250	.250	.250	.250
AF	0.188	0.193		.189	.189	.189	.189	.189
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.138	1.136	1.145	1.145	1.145
AI	0.454	0.474		.460	.460	.459	.460	.459
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.257	.257	.258	.258	.257
AM	1.663	1.683		1.673	1.674	1.673	1.670	1.670
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.783	2.783	2.785
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: JL / mm Date: 01/11/03

Audited by: CR Date: 09/11/03

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	53124
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article **Prototype**

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	5
HAAS Section								
AA	0.115	0.135		.131	.130	.130		
AB	0.290	0.310		.330	.308	.308		
AC	0.040	0.060		.050	.050	.047		
AD	0.115	0.135		.125	.126	.126		
AE	0.240	0.260		.250	.251	.251		
AF	0.188	0.193		.189	.191	.191		
AG	0.240	0.260		.250	.250	.250		
AH	1.126	1.146		1.144	1.144	1.144		
AI	0.454	0.474		.459	.454	.454		
AJ	0.240	0.260		.250	.250	.250		
AK	0.053	0.073		.063	.063	.063		
AL	0.257	0.262		.257	.258	.259		
AM	1.663	1.683		1.671	1.674	1.675		
AN	0.053	0.073		.063	.063	.063		
AO	0.022	0.042		.032	.032	.032		
AP	2.779	2.789		2.786	2.783	2.783		
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: mmw Date: 01/11/03

Audited by: Onk Date: 01/11/03

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	<u>SH</u>

